

Date: Tuesday, 20/01/2009 2:31:57 PM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SPACER  
 Job Number : 44956  
 Estimate Number : 13744  
 P.O. Number :  
 This Issue : 20/01/2009 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL /MED FAB  
 Previous Run :  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A 09-01-19 as per prelim issue DD verified by:ec

Part Number : D38685  
 Drawing Number : D3868 PRELIM  
 Project Number : N/A  
 Drawing Revision : PRELIM  
 Material :  
 Due Date : 26/01/2009 Qty: 4 Um: Each

POSITIVE RECALL

## Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.0088 sf(s)/Unit Total: 0.0353 sf(s)  
 6061-T6 .040 Sheet  
 batch: 157461 UR 9-1-21

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
 1-Cut as per Dwg D3868  
 Dwg Rev: PRE  
 Prog Rev: Lim

2-Deburr if necessary

UR 9-1-21

09/01/21

6 6x

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09.01.22

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
 1- c'sink holes as per dwg D3868  
 2- deburr

FF 09/01/22

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 20/01/2009 2:31:57 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 44956

Part Number: D38685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



ENGINEERING  
A. PRUJAL

68



Comment: INSPECT WORK TO CURRENT STEP

09.01.27

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



6X

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.H. 09/01/27

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M. 09.01.27 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: D 3866-0413

B 44953-2

S.B. 09/01/27

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

Job Completion



U 09.01.27

POSITIVE RECALL

EFFECTIVE

09/01/27

AUTH

RELEASED

DATE

09.02.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



8

7

6

5

4

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1

D

D

C

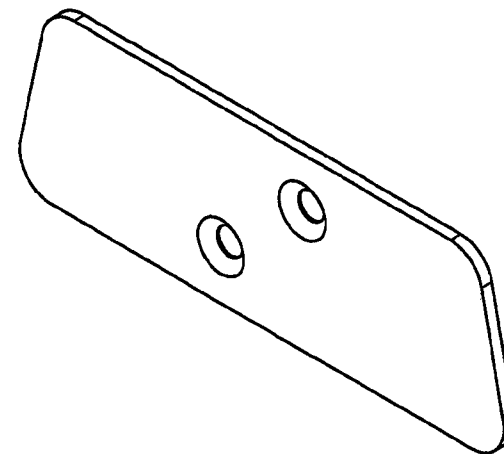
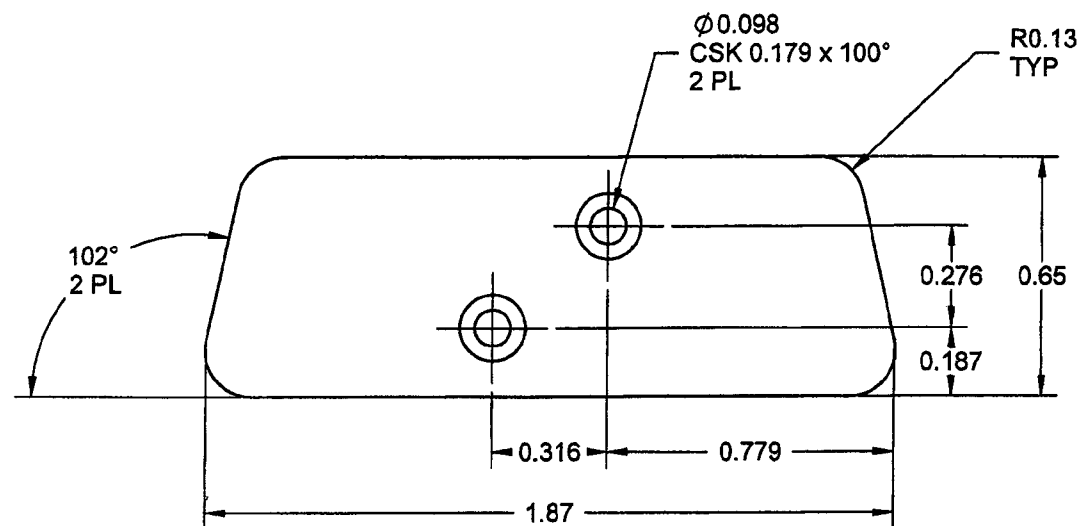
C

B

B

A

A

0.04  
REF**D3868-5 SPACER**

PRELIMINARY ISSUE  
09/01/13 M

44956

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.01 Lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3868	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	09.01.13	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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6

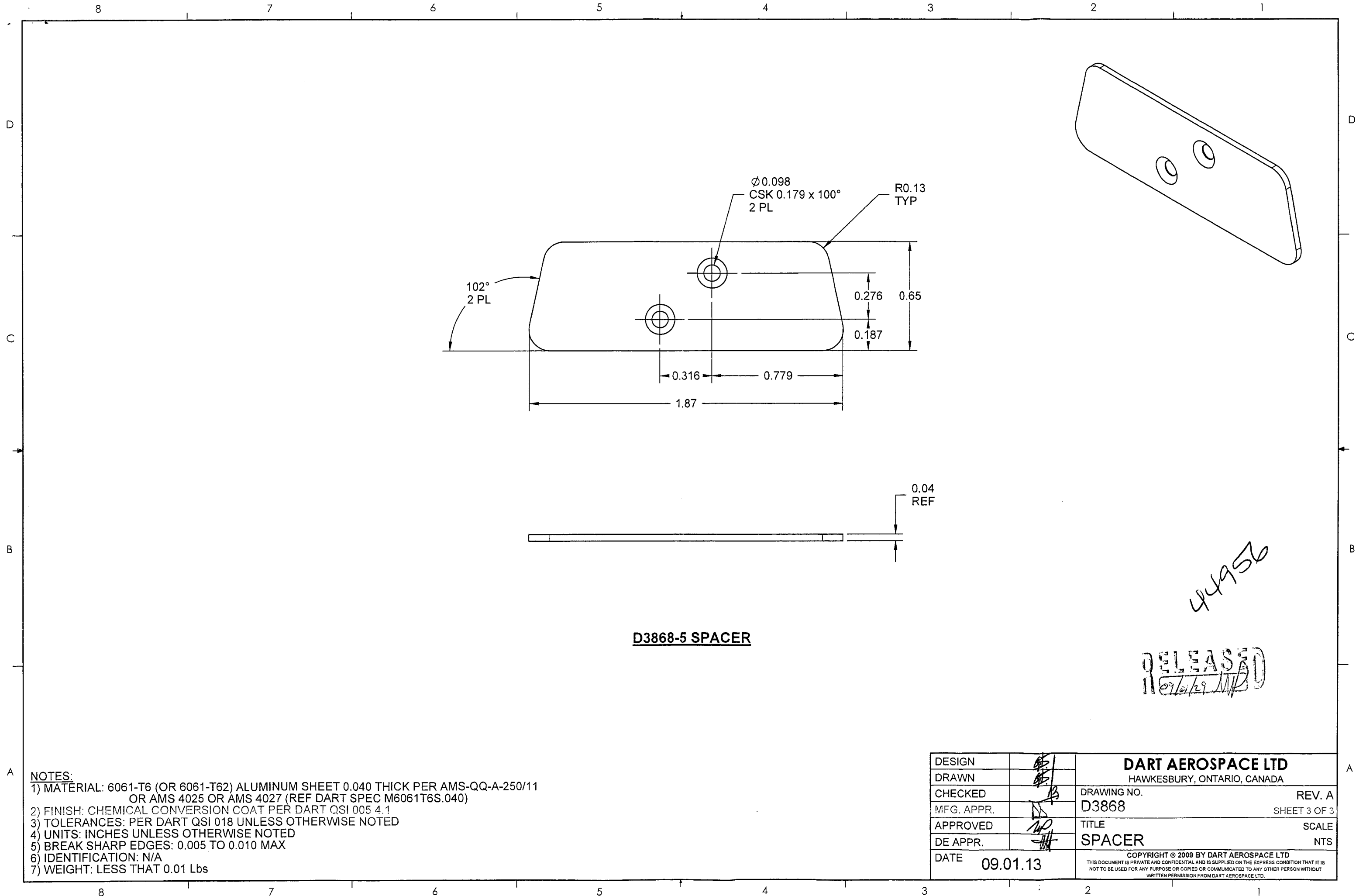
5

4

3

2

1



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- 7) WEIGHT: LESS THAT 0.01 Lbs

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DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3868	SHEET 3 OF 3
APPROVED		TITLE	SCALE
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